

Work Order ID 86529

Wednesday, July 04, 2012 4:06:32 PM

86529

Page 1

Item ID: D2572

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Fwd In 205

Start Date: 7/4/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan: *11* Date: 12074

Tooling:

Date:

Run Start ***NR1***QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2572	Rev E								

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

0.00

HAAS CNC vertical machine #1

MemoProgram Batch No. 86529 Double check by: *11*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

 11 12/07/05
 12.7.29 8 4

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

0.00

Conventional Milling Machine

Memo

Machine keyway as per dwg D2571 & D2572

 11 12.7.29 8 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86529

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/4/2012 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 7/11/2012 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

0.00

120

QC

Memo

0.00

8/12/07/25

8

5

Quality Control

0.00

130

QC

Memo

0.00

DAS
14
9-89

12/07/30

2

2

0.00

140

HandFinish

Memo

0.00

8

2012-7-31

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D2572 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Fwd In 205
 Start Date: 7/4/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 7/11/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating M121841	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 9:30 OVEN TEMPERATURE: 320 F FINISH TIME: 10:00	0.00				8X			M121841 12/07/31
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00				8x			M121841 12/07/31
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: 31441 Memo	0.00				8			12/07/31 JB

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Page 4

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Item Name: Saddle, Fwd In 205
Start Date: 7/4/2012 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 7/11/2012 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/8/11 
MLJ 12/07/13

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 04, 2012 4:06:38 PM

Page 1

Work Order ID: 86529

86529

Parent Item: D2572

D2572

Parent Item Name: Saddle, Fwd In 205

Start Date: 7/4/2012

Required Date: 7/11/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-005		Manufactured	No			100	Each	53.0000	1	8			
-----------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D6101-005

**

Saddle Billet

Location

Loc Qty

Loc Code

MAT041

2

76838

2

MAT044

51

79874

19

81973

4

85429

28

8

PK 12/07/19.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 86529
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.499	.499	.499	.499		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.565	.565	.565	.565		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.497	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.127	.127	.127	.127		
Q	0.115	0.135		.126	.126	.126	.126		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.127	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.130	.132	.132	.132		
X	0.307	0.312		.310	.310	.310	.310		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.360	.360	.360	.360		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.3862	1.3863	1.3882	1.388		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.251	.251	.251	.251		
AI	2.000	2.020		2.0014	2.0013	2.003	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: <i>ST</i>	Audited by: <i>DAS</i>
Date: 12/07/24	Date: 12/07/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	86529
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				51	62	78	84		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
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H	0.375	0.380		.376	.376	.376	.376		
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J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.565	.565	.565	.565		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
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W	0.115	0.135		.132	.132	.132	.132		
X	0.307	0.312		.316	.310	.310	.310		
Y	0.760	0.765		.763	.763	.763	.763		
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AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.3885	1.388	1.388	1.388		
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AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.251	.251	.251	.251		
AI	2.000	2.020		2.0045	2.003	2.003	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF
Date:	12-7-29

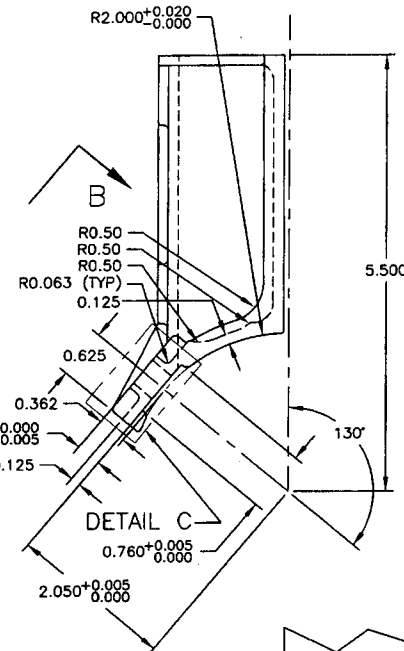
Audited by:	DAS
Date:	12/07/30

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
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SUBJECT TO AMENDMENT

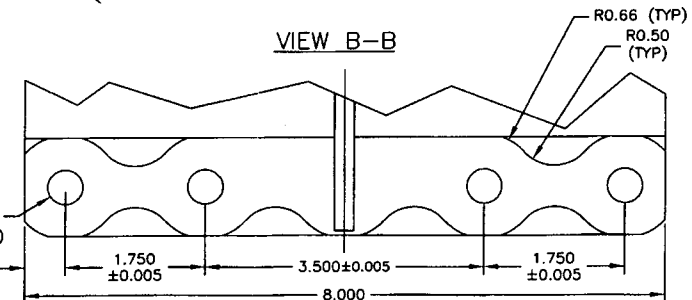
WORK ORDER
NO. 84529

05.12.06 ~~11~~



MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF PART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER PART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
PART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER PART QSI 018 UNLESS OTHERWISE NOTED




- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)
- E



VIEW B-B

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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
		DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED 	APPROVED 	DRAWING NO. D2572
DATE 05.07.13		REV. E SHEET 1 OF 1 TITLE INNER FWD SADDLE SCALE 2.3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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